

Date: Monday, 06/10/2008 10:48:00 AM
 User: Julie Lécocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350 SKIDTUBE ASSEMBLY RH
Job Number :	42452		
Estimate Number :	10268		
P.O. Number :		Part Number :	D350636014
This Issue :	06/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2750 REV F
First Issue :	1/1	Project Number :	N/A
Previous Run :	42451	Drawing Revision :	F
	Type :	Material :	
	SKIDTUBES	Due Date :	30/10/2008
Written By :		Qty:	1
Checked & Approved By :	JLD 08.10.06	Um:	Each
Comment :	Est Rev:H 02.09.25 Rearranged procedure steps KJ Est Rev:I 05.12.08 Rearranged procedure steps EC Est Rev:J 06.03.30 Per rev. D EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-09-23 revF as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.10.20



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 004

5 08/11/04

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1

D2600-3-Bent

Extrusion (Bent)

42342 D 47-10-7

3.0	D2744	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

539212

D

42342

7-10-7 M

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

47-10-7

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 . 2708-1008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 10:48:00 AM
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Job Number: 42452

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

M 8-10-14

4-Drill pilot holes for Detail G using DT8329.

5-Open up holes for Detail B to 0.375 (2 holes per side) and blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

RT
08-10-08

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297" ***Make sure that wearplate holes are on bottom of tube*** Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod M109213 BE 08/10/07

10-Grind welds flush as per Dwg D2750 RT 08-10-06

11-Countersink Detail A as per dwg D2750.

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/09 (X)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/09 (X)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 8-10-14 D

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RT 08-10-14

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: 42 562

JD 8-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42452

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: 892185 BE 08/10/10

11.0	D34905	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: 832597 BE 08/10/10

12.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch: 238755 (4P) BE 08/10/10

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes section T-T 0.500" (4 per side) as per dwg D2750

2-Open holes section V-V 0.3125" (4 per side)

3-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: m109338

exp. date: 8-11-01

JB 8-10-10

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 5)

A/R

Aluminum Rod

batch: m109213

BE 08/10/10

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

JB 8-10-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

10-Deburr holes

14.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/06/21 (X)

15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/21 (X)

(PK) →

16.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-J 08/11/01

(1X)

17.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:40
320°F
11:10

M-J 08/11/01

(1X)

18.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-11-03 (X)

19.0 ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Insert

Batch: M100621

M-J

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

M-J 08-11-03 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-014 PAR #: N/A Fault Category: Prod - Slud tube NCR: Yes No DQA: 11 Date: 08-11-10
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: 11 Date: 08/11/11

NCR: <u>42452</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/10/20	15.	During inspection it was found that the two two Fwd 0.500" holes were opened at the wrong angle.		<ul style="list-style-type: none"> Verify drill jig 11R Remove & replace the 2 Fwd x-bolt spacers B42185 x2 Lift the x-bolt spacers 0.050" each side & pin into place. 	BE 08/10/21	8/10/21	Q51012	08/10/20
		the Inside holes are too low, opened R.C. employee at holes at an angle		<ul style="list-style-type: none"> weld per Q51012 AIR M109213 grind flush. 	BE 08/10/21	8/10/21	Q51012	08/10/21

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 42452

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: 1341114

JS

22.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: 1342418

JS

23.0	D37931	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: 1342639

JS

24.0	D37933	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: 1342247

JS

25.0	D37941	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: 1342480

JS

26.0	D37943	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: 1339713

JS

27.0	D353525	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1341633

JS

08-11-03

(22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 42452

Part Number: D350636014

Job Number:



Seq. #: Machine Or Operation: Description :

28.0 D353625 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B42234 *HL*

29.0 D35371 Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

WEARPAD

Batch: B42235 *HL*

30.0 D36311 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

Batch: B41141 *HL*

31.0 D3488042 Blade Fitting Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade Fitting, RH

Batch: B42415 *HL*

32.0 D3492041 Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B42182 *HL*

33.0 D3492045 Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B42184 *HL*

34.0 AN3C5A Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)

Bolt

Batch: M109752 *HL*

08-11-03

(XV)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 42452

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	AN3C6A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M108880

JL

36.0	AN6C44A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M1109765

JL

37.0	AN8C35A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M106896

JL

38.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: M1109545

JL

39.0	AN960C816L	WASHER
------	------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M1108928

JL

40.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M1109249

JL

41.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M1109485

JL

08-11-03

XU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 42452

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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42.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M108464

Handwritten initials

43.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Assemble tube hardware as per dwg D2750 sikaflex batch: M109449 08/11

2-Inspect For Foreign Objects

3-Spray inside of tube with "LPS-3" batch: M107912

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M109449

EXP DATE: 08/11

5-Coat all exposed fasteners with "LPS Procyon" batch: M104251

Handwritten: 08-11-03 (X1)

44.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/11/08 (X1)

45.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

46.0	D2741	Blade, 350 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 40724

Handwritten signature and circled 'D'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42452

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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47.0	AN960C816L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M109632

48.0	MS21083C8	NUT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M109740

49.0	AN8C21A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109772

50.0	NAS1515H8L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 108969

51.0	D34931	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 90829

52.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

53.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

Handwritten signature and date: 08/11/04

Handwritten number: B42452

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42452

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/05 [Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

NO. 177

**AWS D17.1.2001
QUALIFICATION TEST RECORD**

Name: Barchy Elliot
Job number: 142449
Part number: 1350-636-013
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[☒]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier David Lind Date of Test Coupon 08/10/20

Welder Barchy Elliot Date of Test Coupon 08/10/20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

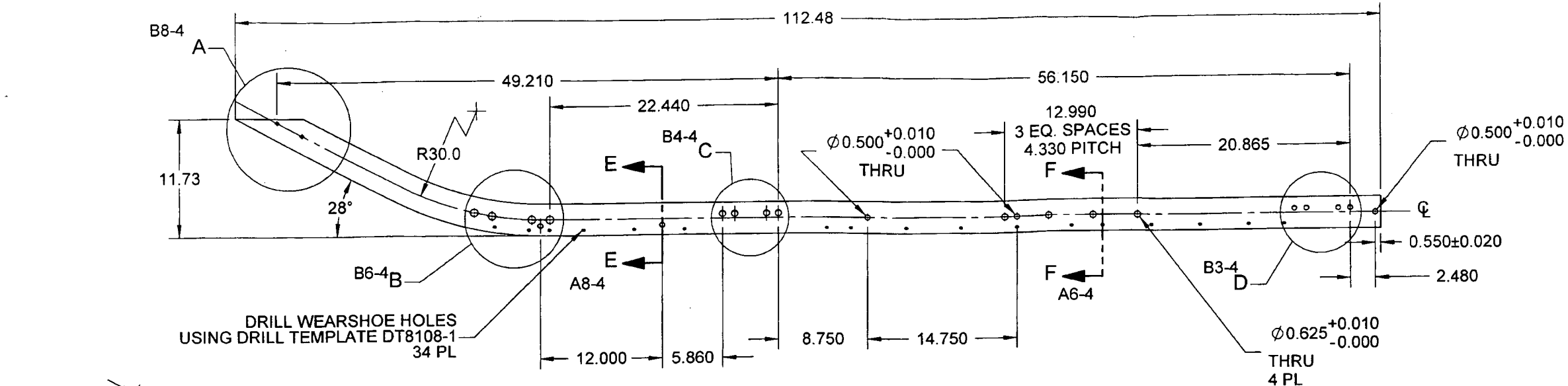
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

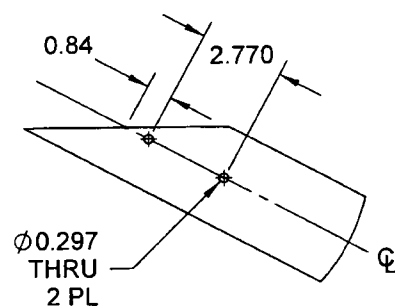
- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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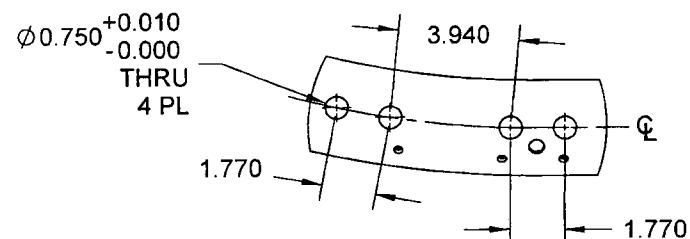
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
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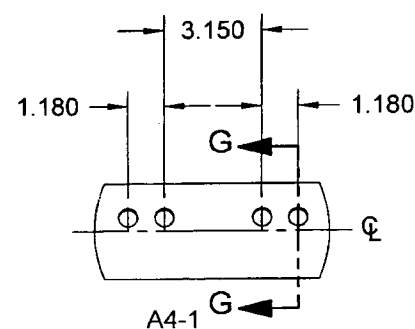
D2750-1 LH SKIDTUBE



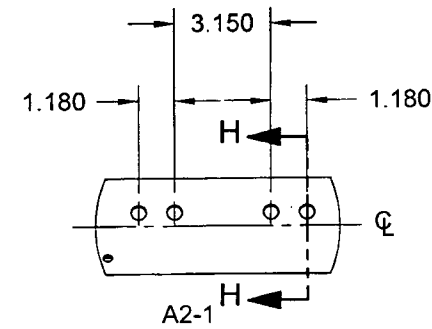
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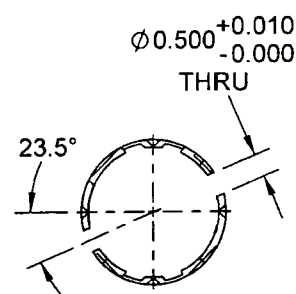
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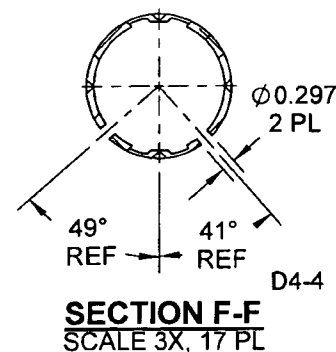
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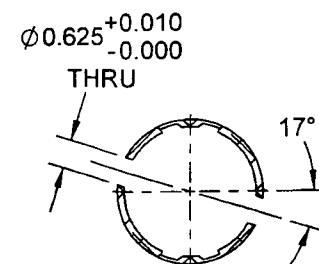
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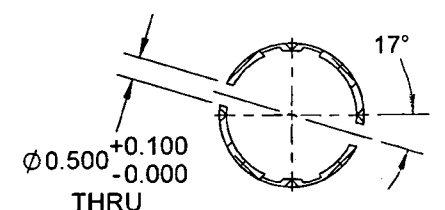
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

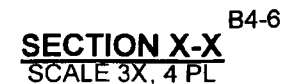
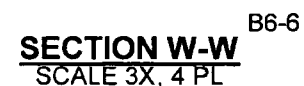
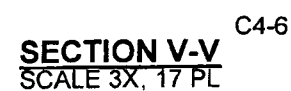


SECTION H-H
SCALE 3X, 4 PL

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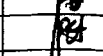
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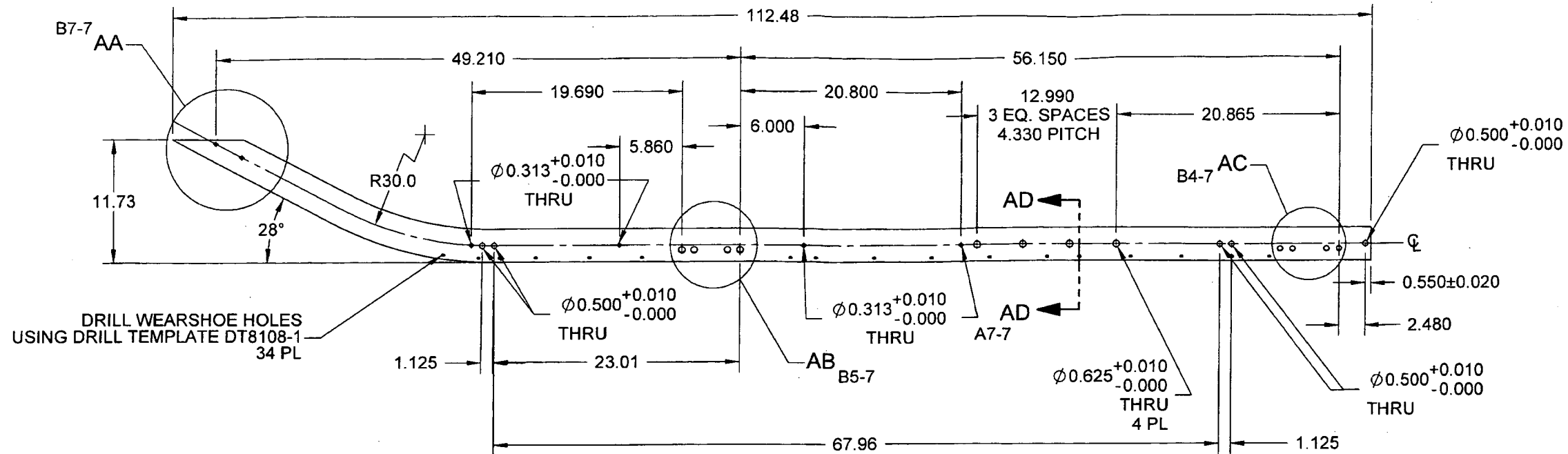
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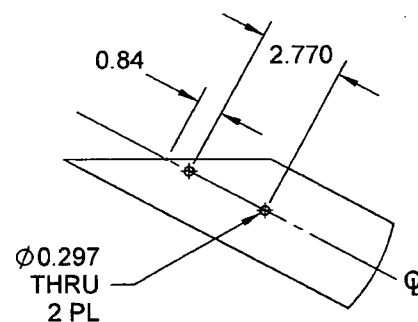
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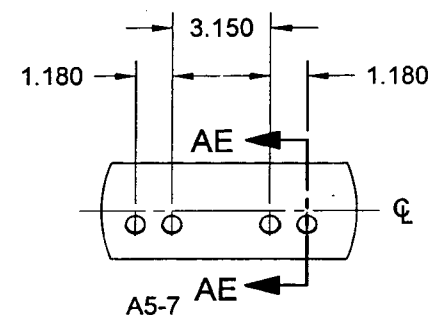
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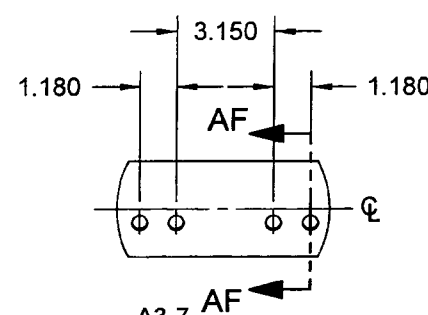
D2750-4 RH SKIDTUBE



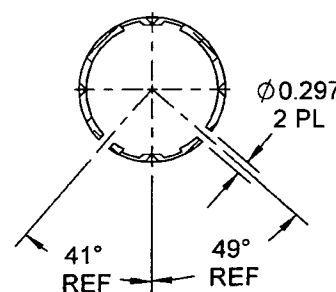
DETAIL AA
D7-7
SCALE 2X



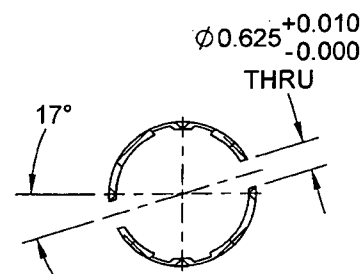
DETAIL AB
C4-7
SCALE 2X



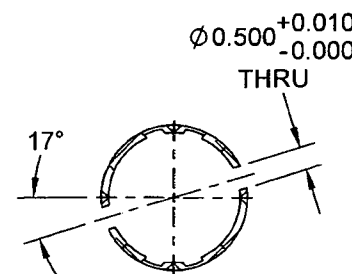
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



SECTION AE-AE
B6-7
SCALE 3X, 4 PL

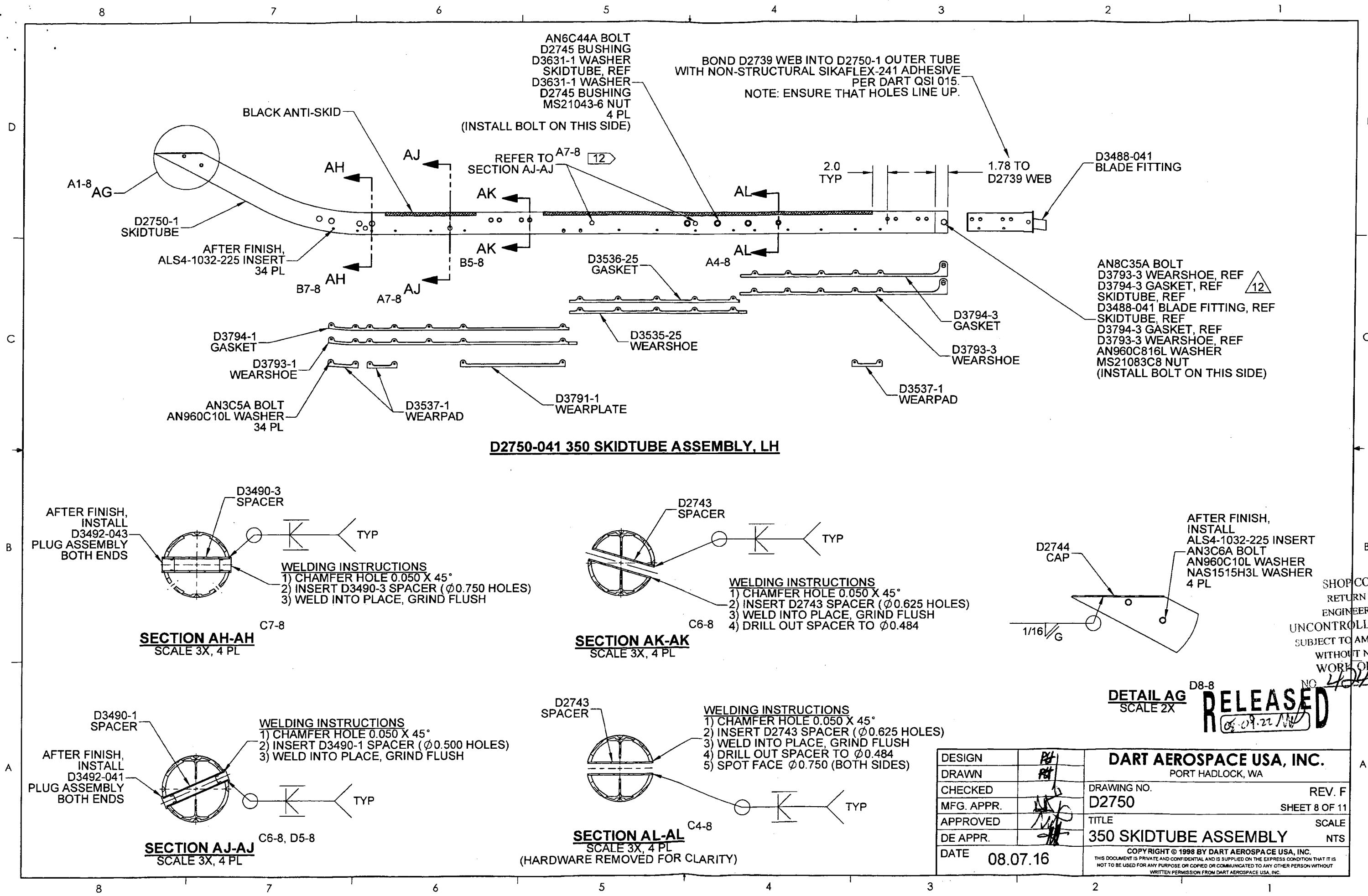


SECTION AF-AF
B4-7
SCALE 3X, 4 PL

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

SECTION AH-AH
SCALE 3X, 4 PL

SECTION AK-AK
SCALE 3X, 4 PL

SECTION AJ-AJ
SCALE 3X, 4 PL

SECTION AL-AL
SCALE 3X, 4 PL

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DETAIL AG
SCALE 2X

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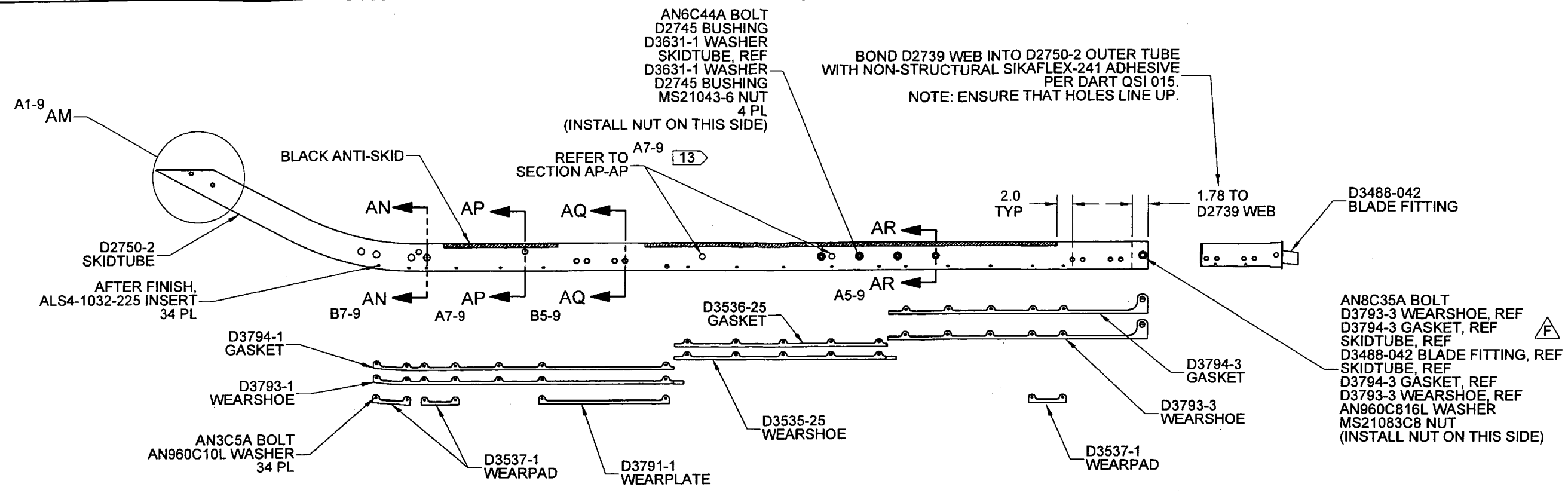
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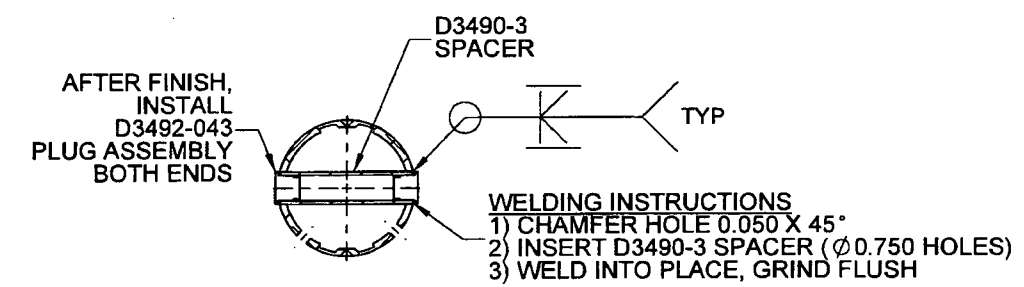
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D
C
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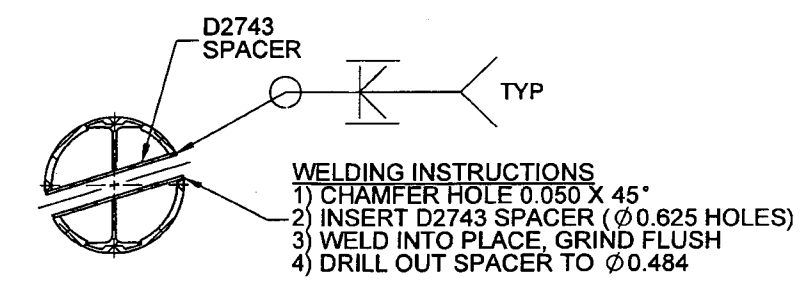
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C
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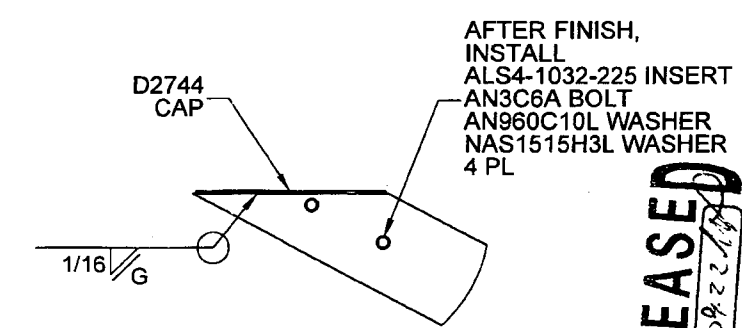
D2750-042 350 SKIDTUBE ASSEMBLY, RH



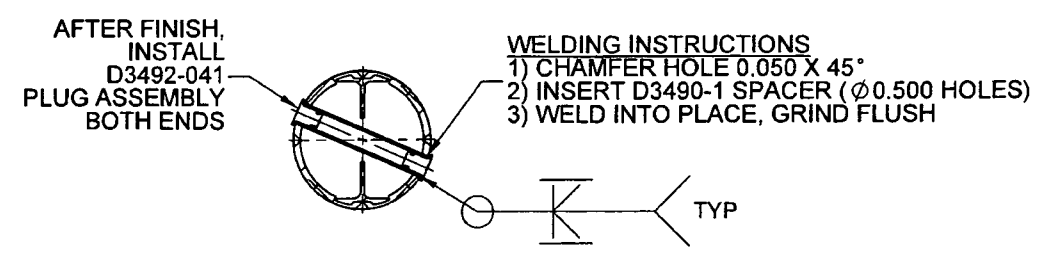
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SCALE 3X, 4 PL



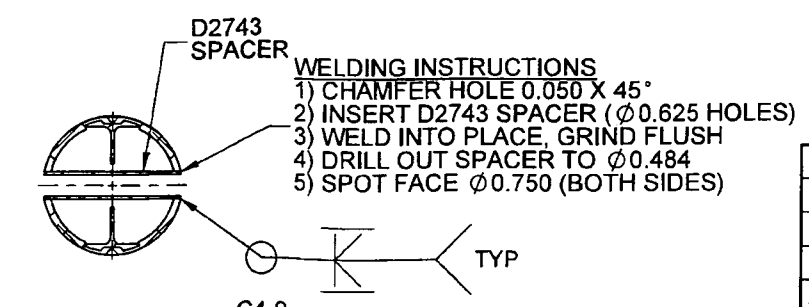
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SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL

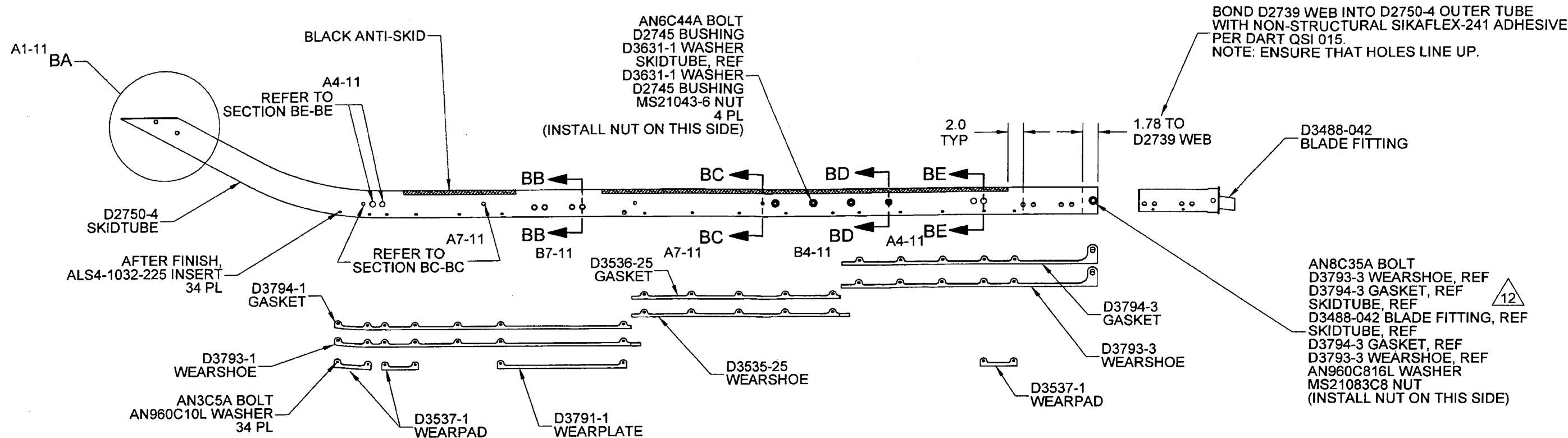


SECTION AR-AR
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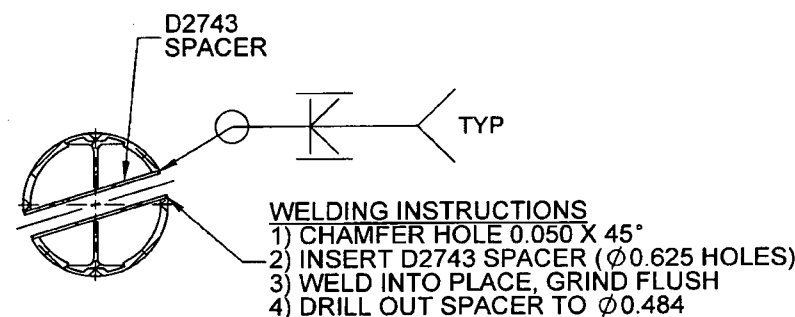
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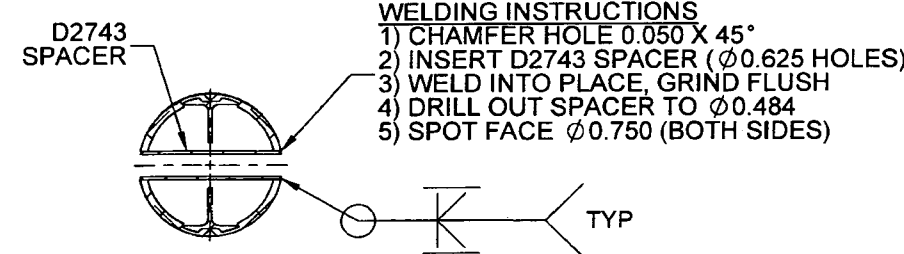
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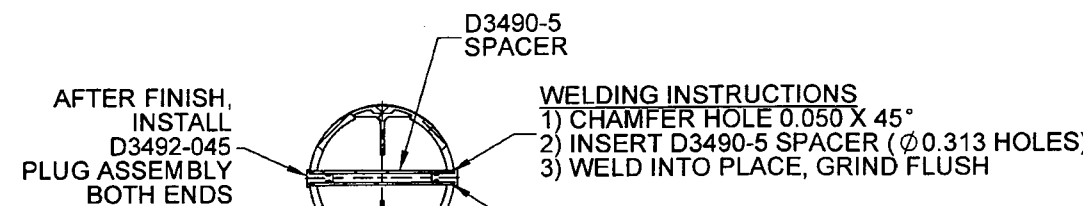
D2750-044 350 SKIDTUBE ASSEMBLY, RH



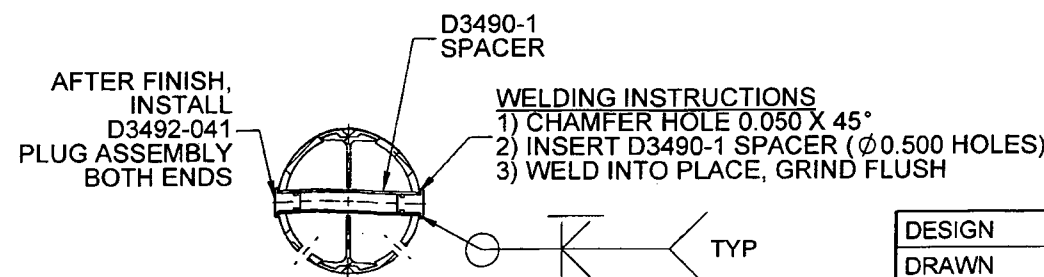
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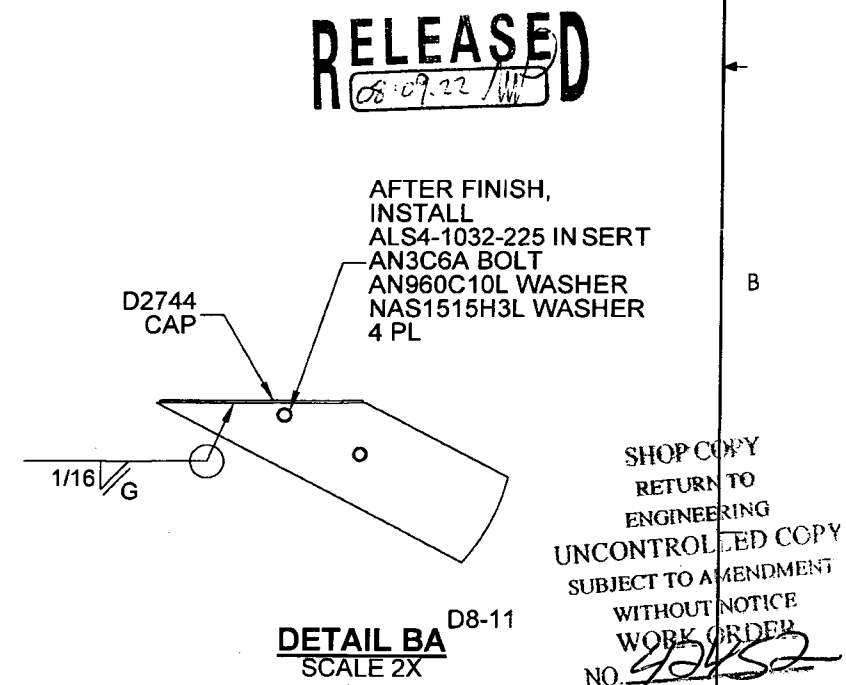
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SCALE 3X, 4 PL
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SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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